

Work Order ID 61104

Friday, August 06, 2010 9:50:10 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 8/6/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/19/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *RA*Date: *10-8-06*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2580	Rev D

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

*8/10/08/3/**M 10-8-06*

110

0.00



CNC Bend 1

BENDING MACHINE - SKIDTUBES

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

*(IX) MB 10-08-19***B61104**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
Skidtubes	Memo	0.00							
Skidtubes	1- Deburr ends								
	2- C'sink holes as per dwg without cutting fluid								
	3- Prepare tube for welding, remove alodine as required.								
	4- Scribe batch number insied aft end of tube.								
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

(IK) ~~12~~ MB 10-08-19

1 — BE 10/08/23



W/O:		WORK ORDER CHANGES					
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Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod

M114877 BE 10/08/23

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod

M114877 BE 10/08/23

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

BE 10/08/25

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Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8/10/08/25

160 QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/08/25

170 Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

✓ Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

7/10/08/25

②

1/0

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 8:35 OVEN TEMPERATURE: 820 FINISH TIME: 9:05	0.00 0.00							
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

① 10-8-26

ml 10 08 30 ①

W/O:		WORK ORDER CHANGES					
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Customer:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

mm 10 08 30

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ Sikaflex-291 ☐ 115114 ☐ ☐

Sikaflex expire date: 11/01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ Sikaflex-291 ☐ 115114 ☐ ☐

Sikaflex expire date: 11/01

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 115028

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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220



Packaging

Packaging

Packaging

0.00

0.00

Memo

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: REV I

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10/09/0110/09/01

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Page 1

Work Order ID: 61104

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 8/6/2010


Required Date: 8/19/2010

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP Rev:N02.08.28FP was QC5 in Step 27; Added QC5 to Step 30KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2580-1		Manufactured	No			110	Each	4.0000	1	1			
													
205 Skidtube bent detail													


Location	Loc Qty	Loc Code
LG	1	
57028	1	
ST046	3	
59856	2	
59913	1	

8.61190 MB 10-08-19

D2576-3		Manufactured	No			140	Each	84.0000	1	1			
													
Step (maching detail)													

Location	Loc Qty	Loc Code
LG	84	
46661	36	
52215	48	

BE 10/08/23

D2579		Manufactured	No			140	Each	327.0000	20	20			
													
Crossbolt Spacer													

Location	Loc Qty	Loc Code
LG	327	
57052	5	
57348	4	
58433	2	
59113	182	
60845	134	

20 BE 10/08/23

Dart Aerospace Ltd

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Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 8/6/2010

Required Date: 8/19/2010

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200 Each

81.0000

1

1



Cap

Location

Loc Qty

Loc Code

FP6

1

56613

1

ST026

80

50513

1

50770

28

51539

2

~~53791~~

49

AN3-5A

Purchased No

200 Each

1,542.000

2

2



Bolt

Location

Loc Qty

Loc Code

ST350

1542

105057

542

115016

500

115371

500

AN960JD10L

NAS1149D0332J Purchased

No

200 Each

2,633.000

2

2



Washer

Location

Loc Qty

Loc Code

ST348

2633

110985

2633

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Start Date: 8/6/2010

Required Date: 8/19/2010

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130 ALS4-1032-130 Purchased

No

200

Each

878.0000

50

50



Insert

B# 114723

Location

Loc Qty

Loc Code

FP

861

115079

861

ST282

17

113238

17

10-08-30

AN3C4A

Purchased

No

200

Each

1,889.000

50

50



BOLT

Location

Loc Qty

Loc Code

ST350

1889

114108

14

114416

12

114523

2

114941

861

115300

1000

10-08-30

AN960C10L

NAS1149C0332 Purchased

No

200

Each

29.0000

50

50



washer

Location

Loc Qty

Loc Code

ST245

29

107534

29

10-08-30

B# 115000

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Parent Item Name: Replacement Skidtube

Start Date: 8/6/2010

Required Date: 8/19/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-13

Manufactured No

200

Each

33.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP

2

53461

2

FP012

31

59661

23

60209

8

ml 10.08.30

D3566-5

Manufactured No

200

Each

36.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP

22

60869

22

FP015

14

59158

14

ml 10.08.30

D3566-1

Manufactured No

200

Each

30.0000

2

2



Gasket

Location

Loc Qty

Loc Code

FP

13

60857

13

FP015

17

57715

2

59126

3

60202

12

ml 10.08.30

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Start Date: 8/6/2010

Required Date: 8/19/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-11
Wearshoe

Manufactured No

200 Each

8.0000

1 1

Location

Loc Qty

Loc Code

FP019

8

59941

8

D3564-13
Wearshoe

Manufactured No

200 Each

31.0000

1 1

Location

Loc Qty

Loc Code

FP17

31

59660

19

60862

12

D3564-9
Wearshoe

Manufactured No

200 Each

24.0000

1 1

Location

Loc Qty

Loc Code

FP

1

55334

1

FP019

23

59201

10

60236

13

ml 10-08-30

ml 10-08-30

ml 10-08-30

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Start Date: 8/6/2010

Required Date: 8/19/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

200

Each

27.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FG

1

34806

1

FP19

2

57525

1

58709

1

FP-19

24

59157

11

60868

13

mm 10.08.30

D2594-3

Manufactured No

200

Each

379.0000

16

16



O-Ring, 205 Skidtube

Location

Loc Qty

Loc Code

FP

379

55546

19

58191

12

59358

348

mm 10.08.30

D2594-1

Manufactured No

200

Each

419.0000

16

16



Plug, 205 Skidtube

Location

Loc Qty

Loc Code

FP

183

42807

112

55002

71

FP14

236

58434

47

59110

189

mm 10.08.30

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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY

RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

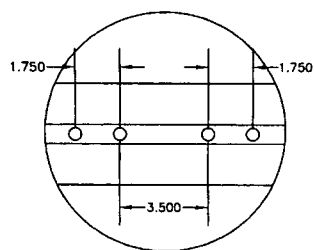
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

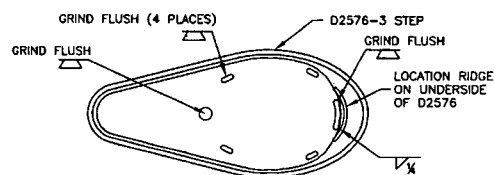
NOTE: Date & initial all entries

DETAIL A
SCALE 5:24

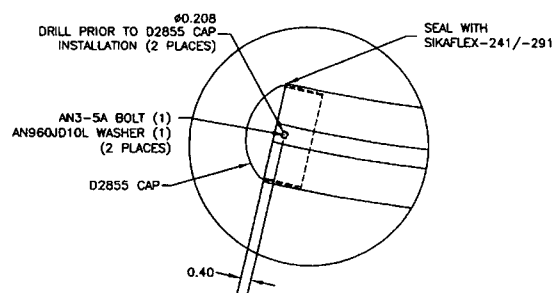


RELEASED
07-06-28

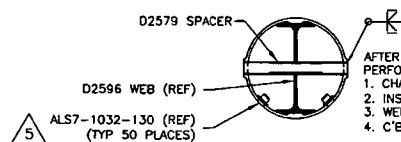
DETAIL B
SCALE 5:24



DETAIL C
SCALE 5:24



SECTION D-D
SCALE 5:24



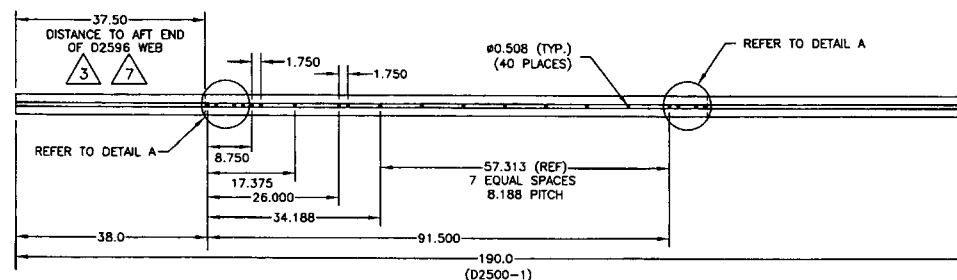
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO $\phi 0.437$ X 1.00 DEEP

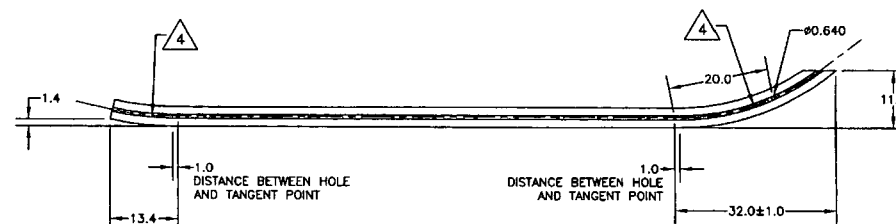
D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

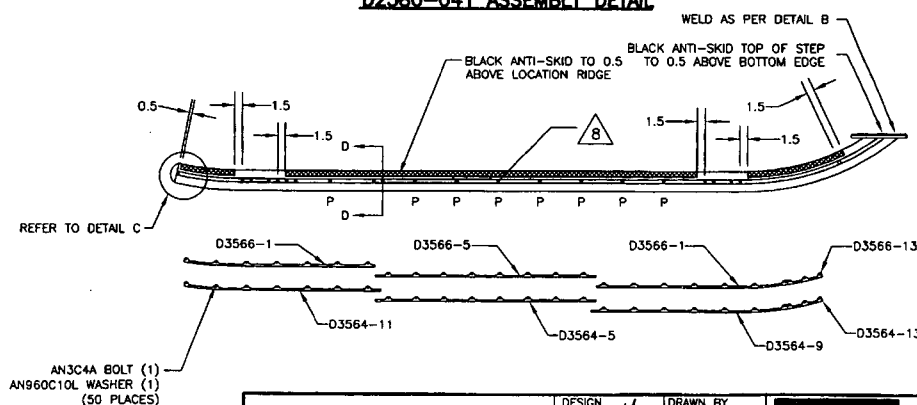
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



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DESIGN	11
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DRAWN BY

CHECKED *41*

APPROVED

DATE _____

DART

DART AEROSPACE LTD.
HAMMERSLEY, ONTARIO, CANADA

DRAWING NO.

D2580

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45
DATE	TIME	LOCATION	TYPE	STATUS	PRIORITY	ASSIGNED TO	COMMENTS	ACTION	RESULT	EVALUATION	REMARKS	SUGGESTIONS	CONCLUSIONS	RECOMMENDATIONS	FOLLOW-UP	ACTION PLAN	TIMELINE	MILESTONES	DEADLINES	RESPONSIBILITIES	ACCOUNTABILITY	TRANSPARENCY	INTEGRITY	ETHICS	COURTESY	COMMITMENT	DIVERSITY	EQUITY	INCLUSION	PARTICIPATION	COLLABORATION	SYNERGY	INNOVATION	CREATIVITY	ADAPTABILITY	AGILITY	RESILIENCE	PERFORMANCE	PRODUCTIVITY	EFFICIENCY	EFFECTIVENESS	IMPACT	VALUE	CONTRIBUTION

205 SKIDTUBE ASSEMBLY

REV. D

SHEET 2 OF 3

SCALE

1:34

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

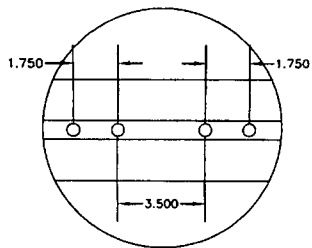
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

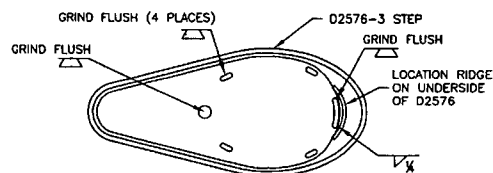
WLB. 64104

DETAIL E
SCALE 5:24

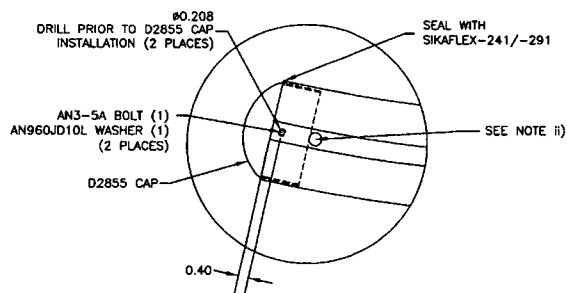


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07.16.18

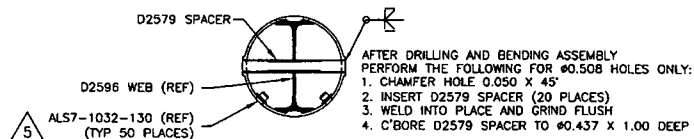
DETAIL F
SCALE 5:24



DETAIL G
SCALE 5:24



SECTION H-H
SCALE 5:24

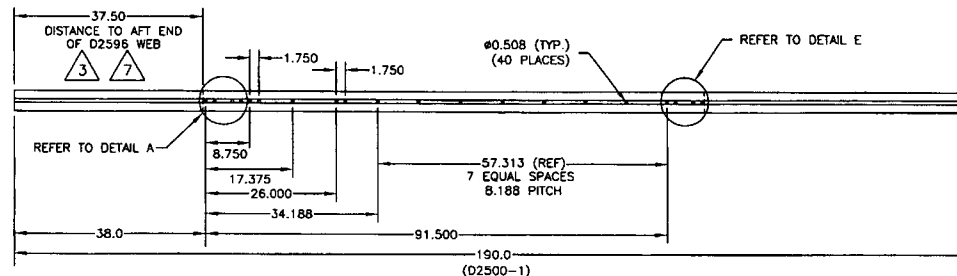


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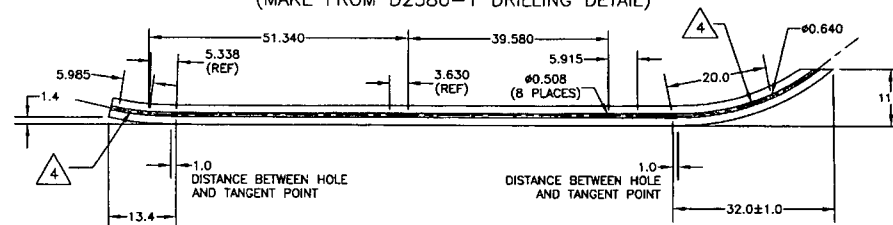
D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

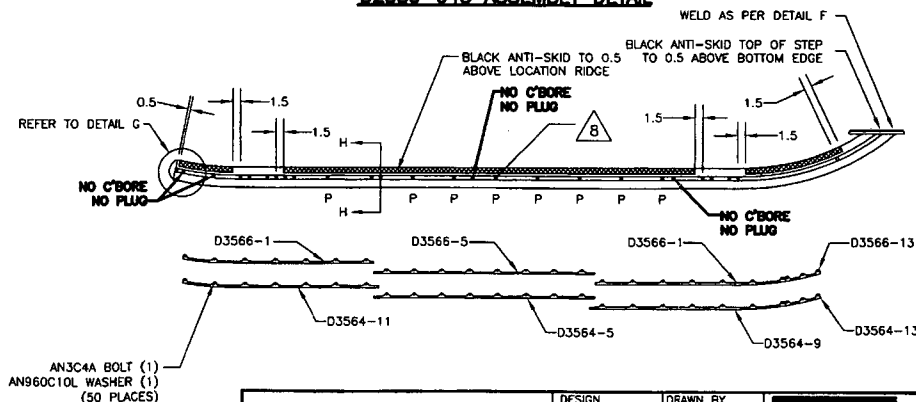
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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DESIGN RH	DRAWN BY RH	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D2580	REV. 0 SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 238

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 61352
Part number: D205-634-041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Paul D. D. Date of Test Coupon 10.08.25
Welder Barclay Elliott Date of Test Coupon 10.09.25

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Work Order ID 61104

Friday, August 06, 2010 9:50:10 AM

Page 1

Item ID: D205-634-041

Revision ID:

Item Name: Replacement Skidtube

Start Date: 8/6/2010 Start Qty: 1.00

Required Date: 8/19/2010 Req'd Qty: 1.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals: Process Plan:

Date: 10-8-06

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2580	Rev D								

106
DOCUMENT CONTROL 0.00

DC
Memo 0.00

Document Control Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

10-8-06

110
BENDING MACHINE - SKIDTUBES 0.00

CNC Bend 1
Memo 0.00

CNC Delta 100 Bender 1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube